



Dart Aerospace Ltd.
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D4011-1

Job Sheet 200157



Part No: D4011-1

Job Qty: 30 pcs

Part Name: Clamp, Short



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/9/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/7/19

Description:

Type: Stock

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B 11.05.19 MADE IN HOUSE DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Omax - 1	30 pcs	10/7/19	10/7/19	0.17	1.33	Waterjet - Flow		SRB 10/12/19
							Waterjet - Omax		
120	QC 8	30 pcs	10/7/19	10/7/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	30 pcs	10/7/19	10/7/19	0.25	1.53	Small Fab - Brake - 1 - B4B		DAS 30 NOV 11 2019 9-89
							Small Fab - Brake - 2 - B4B		

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Container No: S222131

Part: D4011-1

Job No: 200157

Serial No/Batch: S222131

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/12/19

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				Small Fab - Brake - 3 - B4B	
140 QC 5	30 pcs	10/7/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	30 pcs 68 Pcs	10/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	ST544
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	30 pcs 68	10/7/19	0.00 0.00	QC 21 - SA - 21 ✓	ST544
				QC 21 - SA - 70	

DAS
NOV 04 2019 40
B-89

NOV 08 2019

NOV 08 2019

QC 21 - SA - 53

Part Op 100 - 1-Cut as per Dwg Dwg Rev: C Prog Rev: C 2-Debur if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Form as per dwg)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Identify as per dwg & Stock Location:)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	2.4000 sf (.08 ea)	100-Waterjet - Omax - 1	5216339

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M304S14GA	2	14	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp, Short	0.266Inches + 0.006 - 0.001	0.272 0.265	0.267	Diameter
2	Clamp, Short	0.328Inches ± 0.010	0.338 0.318	0.329	
3	Clamp, Short	0.750Inches ± 0.030	0.780 0.720	0.754	
4	Clamp, Short	1.000Inches ± 0.030	1.030 0.970	1.009	
5	Clamp, Short	1.250Inches ± 0.030	1.280 1.220	1.250	
6	Clamp, Short	0.250Inches ± 0.030	0.280 0.220	0.253	
7	Clamp, Short	0.130Inches ± 0.030	0.160 0.100		
8	Clamp, Short	4.490Inches ± 0.030	4.520 4.460		
9	Clamp, Short	1.800Inches ± 0.030	1.830 1.770		
10	Clamp, Short	6.454Inches ± 0.010	6.464 6.444		
11	Clamp, Short	7.270Inches ± 0.010	7.280 7.260		
12	Clamp, Short	8.080Inches ± 0.030	8.110 8.050		
13	Clamp, Short	0.080Inches ± 0.010	0.090 0.070	0.076	

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Date:

NCR No.

Route update only

Job: _____		DISPOSITION		DEPARTMENT/PROCESS						
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐						
Date :	Sequence #:	QTY Affected :		MRB (QS042)						
Description Work Order Deviation		Disposition								
		Completed By								
		Lead hand / Supervisor								
		QC / QA Coordinator								
Root Cause		FAULT CATEGORY								
☐ Operator	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong							
☐ Manufacturing Process	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance							
☐ Equip/Tooling	☐ BOM/Route	☐ Grain Direction	☐ Drawing							
☐ Handling/Preservation	☐ Broken/Damage/Defect	☐ Weld	☐ Finish							
☐ Material	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing							
☐ Product Improvement	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Out of Sequence	☐ Misread							
☐ Process Improvement	☐ Marks/Chatter	☐ Off-set/Set-up								
☐ Human Factors	☐ Mislabeled									
		Other/Details:								